

July-06-12 11:43:22 AM

Page 1

Time OUT: 7:00 am 12/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86721

July-06-12 11:43:22 AM

86721

Page 2

Item ID: D3281-2L02 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector, Fwd RH (Black)
 Start Date: 7/06/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D3281 and Folio FTA 008 Dwg. Rev. <u>F</u> Folio Rev. <u>D</u>	0.00 0.00				x2			Sh 12/07/24
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				x2			Sh 12/07/24
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				x2			Sh 12/08/08

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NOTE: Date & initial all entries

86721

July-06-12 11:43:22 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

~

Cust Item ID:

2

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

140

2.

Dr.
12/08/08

150

2

Memo

160

0.00

Packaging

Memo

Packaging

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July-06-12 11:43:22 AM

Item ID: D3281-2L02

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector, Fwd RH (Black)

Stop

NS?

Start Date: 7/06/12 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/08/17

112-86-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, July 09, 2012 11:44:52 AM

Page 1

Work Order ID: 86721

86721

Parent Item: D3281-2L02

D3281-21 02

Parent Item Name: Floor Protector, Fwd RH (Black)

Start Date: 7/6/2012

Required Date: 8/3/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A04.07.01New issueKJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL

IPP Rev. C

Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-02

Purchased

No

sf

769.4200

8.666

MI FXS 093-F6006-02

**

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

769.4199879

110877

29.0499879

122033

740.37

8.6738 ft.

Sh.
12/08/00

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	96721
Description: Floor Protector, Fwd RH		Part Number:	D3281-2
Inspection Dwg: D3281	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	12/07/24
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.3"	✓		TAPE DL-01	
17.4	+/-0.100	17.375"	✓		TAPE DL-01	
12.1	+/-0.100	12.05"	✓		TAPE DL-01	
0.95	+/-0.030	0.952"	✓		Vern DL-03	
0.25	+/-0.030	0.251"	✓		Vern DL-03	
0.030	Min	0.059"	✓		CAL TH-DT	
0.070	Min	0.087"	✓		CAL TH-DT	

Measured by:	DL	Date:	12/08/08
Audited by:	SMB (DAS 16) 12/08/15	Date:	
Preliminary Approval:	12-8-15	Date:	

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.07.23	Dwg Rev updated	KJ/DL	
D	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
E	10.09.01	Dwg Rev updated	KJ	
F	11.06.21	Dwg Rev updated	KJ	

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SHOP COPY

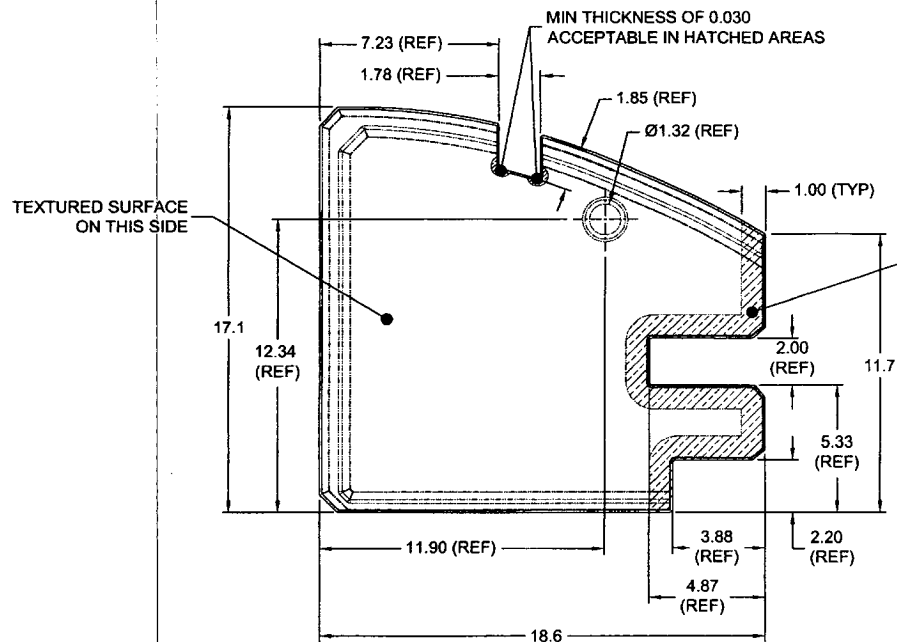
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UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. _____



MIN THICKNESS
OF 0.030
ACCEPTABLE IN
HATCHED AREA

0.95
0.50 (REF)

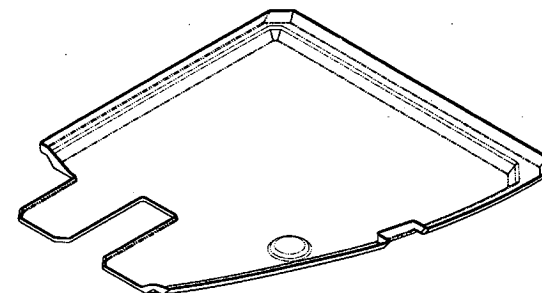
0.25

6
F

D3281-1 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: -1L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-1L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-1Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-1L02 = 0.95 lb D3281-1L08 = 1.13 lb
- 8) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



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WITHOUT NOTICE
WORK ORDER

NO. 86721

RELEASED
2010-11-25

F	NOTES UPDATED. FLAG NOTE 6 WAS 7 & RELOC, D.E.O. D3281-E-1 INC. DIM 17.0 WAS 17.1 (ZN B5-3, B6-4) & 17.7 WAS 17.8 (ZN C5-3, C6-4) REF CAR 10-21.	JPH	10.09.27
E	-3/4 NOW TRIMMED FLAT: RMV 0.25 BEVEL TO FACILITATE TRIMMING (ZN D6-3, D4-4)	CP	10.01.05
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE		10.09.27	
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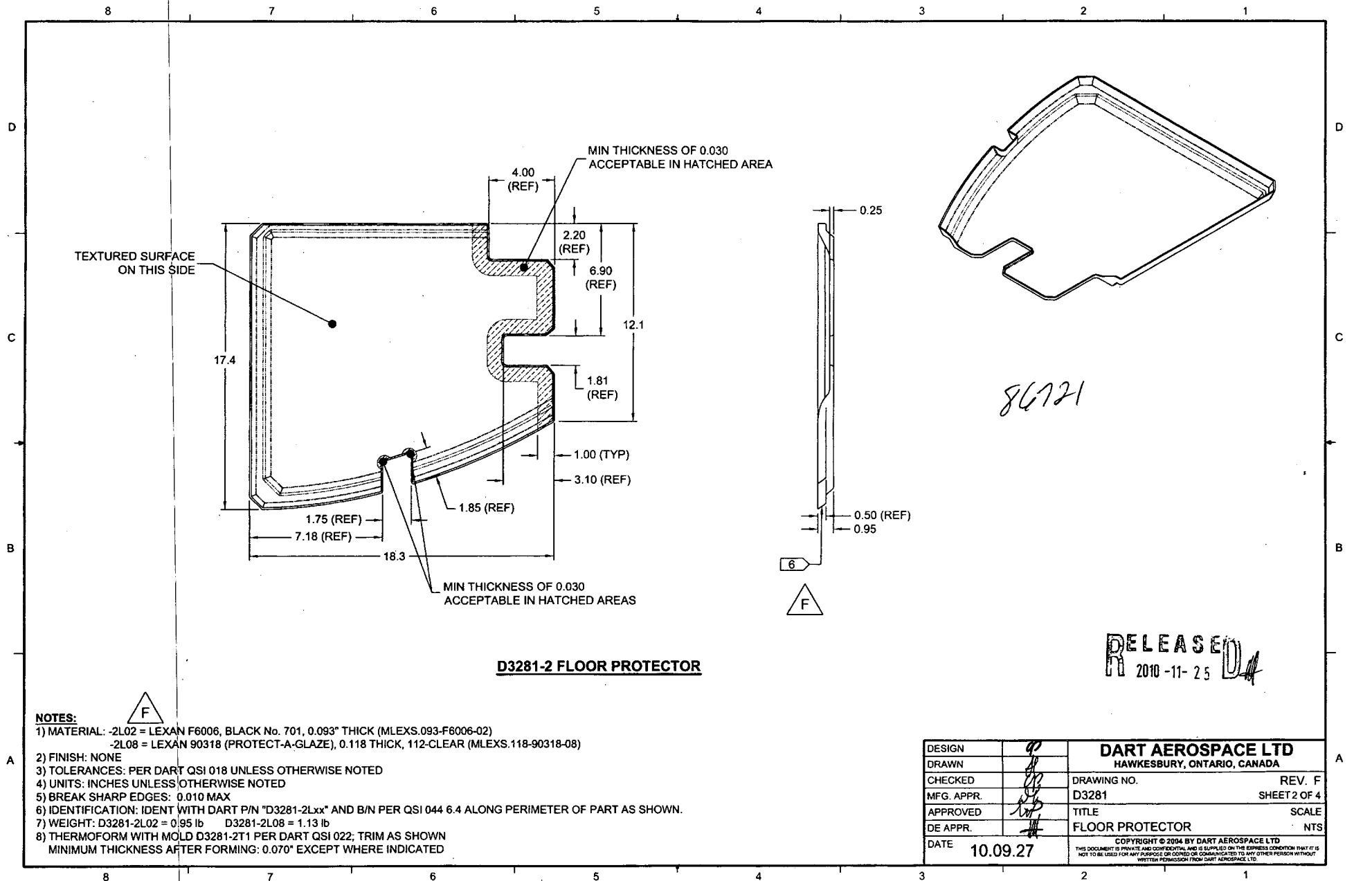
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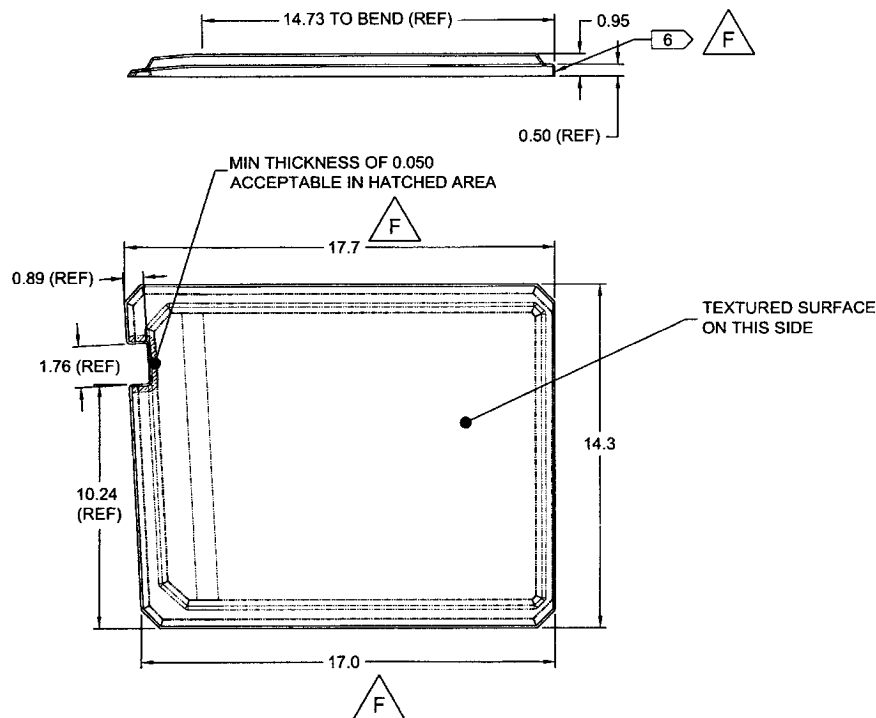
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D3281-3 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T11 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

RELEASE
2010-11-25

DESIGN	<i>JD</i>	DART AEROSPACE LTD	
DRAWN	<i>JD</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JD</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>JD</i>	D3281	SHEET 3 OF 4
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

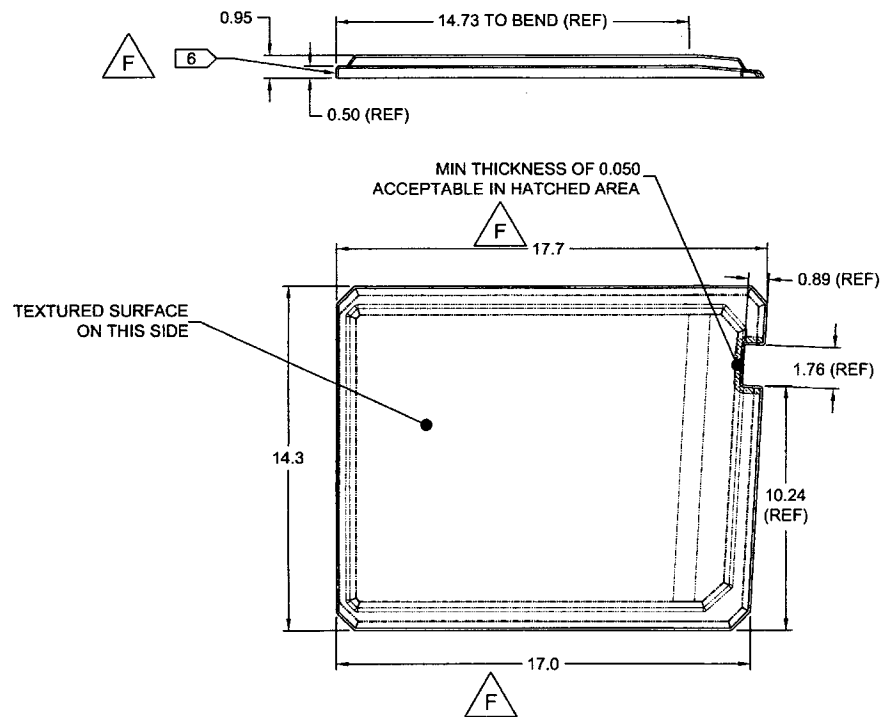
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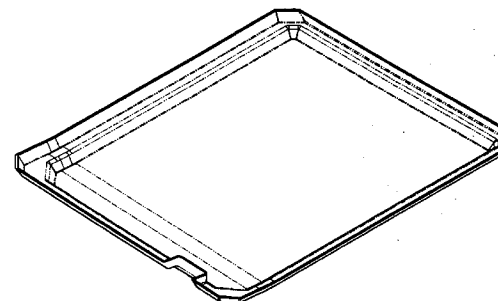
NOTE: Date & initial all entries



D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) MATERIAL: -4L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-4L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFICATION: IDENT WITH DART P/N "D3281-4Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-4L02 = 0.87 lb D3281-4L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



94721

RELEASED
2010-11-25

DESIGN	<i>JD</i>	DART AEROSPACE LTD	
DRAWN	<i>JD</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JD</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>JD</i>	D3281	SHEET 4 OF 4
APPROVED	<i>JD</i>	TITLE	SCALE
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